



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBE105-14101W2-PO

Job Sheet 185055



Part No: RBE105-14101W2-PO

Job Qty: 1 ea

Part Name: Outer Needle Bearings Extractor



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/16/18

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBE105-14101W2 Rev.1 IPP Rev. A 18.10.22 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing	1 pcs	11/16/18	11/16/18	0.00	0.00	Purchasing		DEC 12 2018
110	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging2		DEC 12 2018
120	QC	1 pcs	11/16/18	11/16/18	0.00	0.00	QC6		38
130	Packaging	1 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3		9-89
140	QC21-FG	1 Ea	11/16/18	11/16/18	0.00	0.00	QC21		DEC 12 2018

Part Op 100 - Issue P/O: _____ MANUFACTURE RBE105-14101W2 AS PER DWG Supplier: METEC Certificate of Descriptions: conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBE105-14101W2P	Outer Needle Bearings Extractor	1 (1 ea)	100-Purchasing	5137032

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBE105-14101W2P	1	0	0

Part Specifications

Specifications could not be found.

Plex 10/22/18 12:46 PM dart.Lussier.Patrick



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S137034



Part: RBE105-14101W2

Job No: 185055

Serial No/Batch: S137034

Revision: 1

Inspector:

Exp Date:

Instructions:

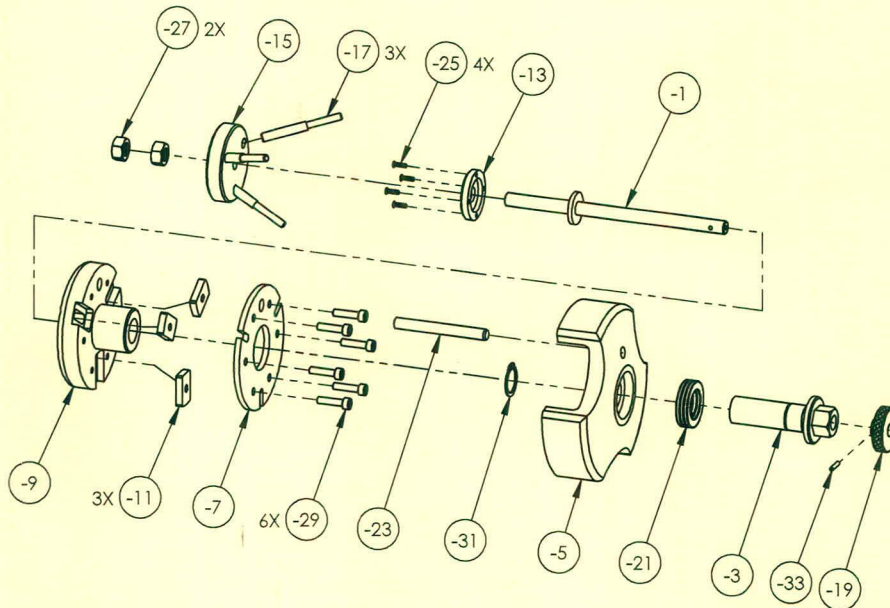
Date: 12/12/18

1882-83
1883-84

1884-85
1885-86

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		RELEASED FOR PRODUCTION	1/21/2016	DPD
				JAG



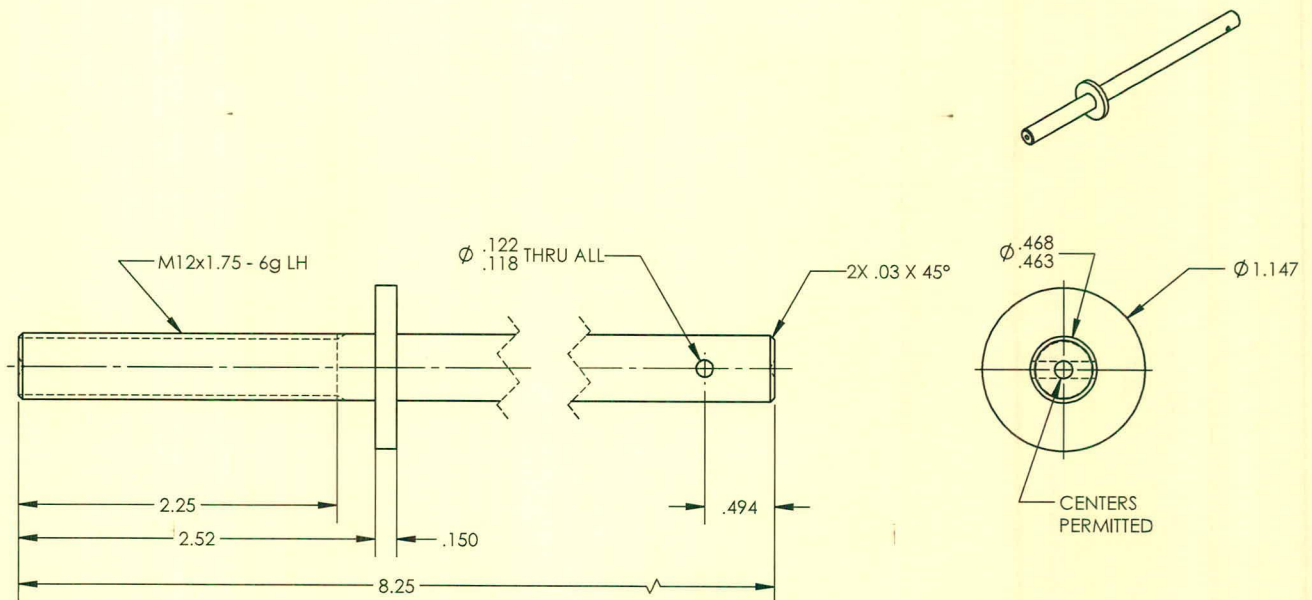
NOTE:
REF. EUROCOPTER T/N: 105-14101W2.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	BOLT	4140/4142 Q & T		2
			-3	1	BOLT WITH THRU HOLE	4140/4142 Q & T		3
			-5	1	DISK	6061		4
			-7	1	PIN PLATE COVER	4140/4142 Q & T		5
			-9	1	PIN PLATE BASE	4140/4142 Q & T		6
			-11	3	PLATE	4140/4142		7
			-13	1	CAP	6061		8
			-15	1	PIN BASE	4140/4142		9
			-17	3	PIN	O-1		10
			-19	1	KNURLED KNOB	6061		11
		B/O	-21	1	THRUST BALL BEARING	STEEL	Ø25mm I.D. X Ø 42mm O.D. X 11mm (SKF #51105)	1
		B/O	-23	1	DOWEL PIN	STEEL	Ø10mm X 90mm (MCMaster-CARR #91595A673)	1
		B/O	-25	4	FLAT HEAD SCREW	STEEL	M3 X 0.5 X 12mm (MCMaster-CARR #91420A122)	1
		B/O	-27	2	LEFT-HAND HEX NUT	STEEL	M12 X 1.75 (MCMaster-CARR #93695A190)	1
		B/O	-29	6	SOCKET HEAD CAP SCREW	STEEL	M6 X 1 X 25mm (MCMaster-CARR #95263A561)	1
		B/O	-31	1	EXTERNAL RETAINING RING	STEEL	Ø24mm (MCMaster-CARR #98541A125)	1
		B/O	-33	1	SPRING PIN	STEEL	M3 X 18mm (MCMaster-CARR #91611A158)	1

DART AEROSPACE	
TITLE EXTRACTOR FOR OUTER NEEDLE BEARING	
DWG NO. RBE105-14101W2	REV 1
MAT'L STEEL	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125
FINISH 10	1. BREAK ALL SHARP EDGES .015 x 45° OR .016
SPEC 1	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
DRAWN BY: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
CHECKED: CLOUGH	USED ON MODEL EC145
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:5	DATE 1/21/2016
SHEET 1 OF 11	

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REVISIONS				
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				APPROVED

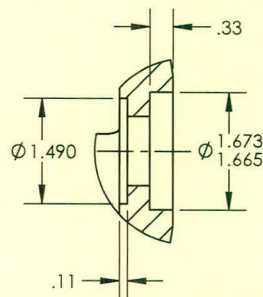
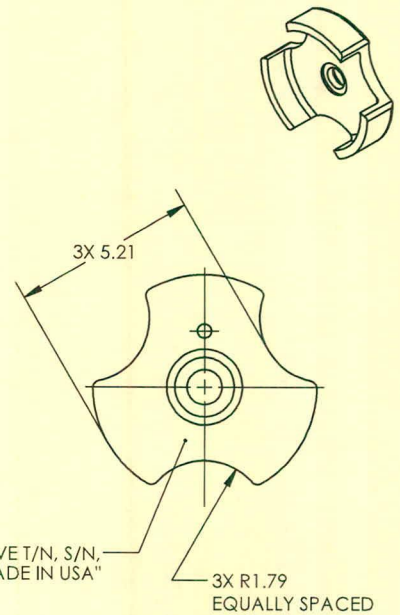
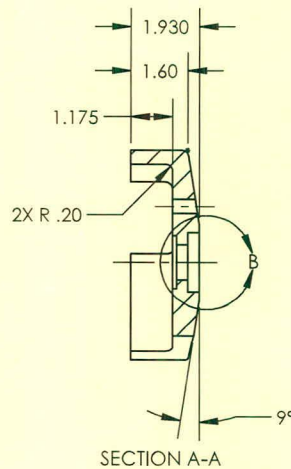
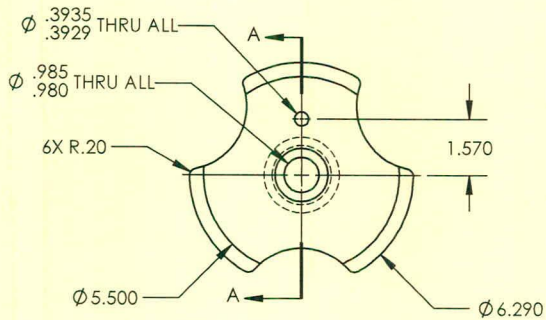


(-1)
BOLT

DART AEROSPACE	
TITLE EXTRACTOR FOR OUTER NEEDLE BEARING	
DWG NO. RBE105-14101W2-1	REV 1
MATERIAL 4140/4142 Q & T	
HEAT TREAT	
FINISH ZINC PLATE	
SPEC ASTM B633 TYPE I SC 2	
DRAWN BY: CLOUGH	UNLESS OTHERWISE SPECIFIED
CHECKED: CLOUGH	DIMENSIONS ARE IN INCHES
OPPS APPR: ANDERSON	.XXX ± .005 FRACTIONS ± 1/8
QA APPR: LINDSAY	.XX ± .01 ANGLES ± 5°
APPROVED: GILBERT	.X ± .1 SURFACES = 125
SCALE 1:1	DATE 12/30/2015
SHEET 2 OF 11	

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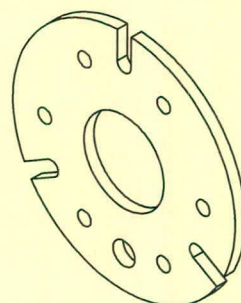
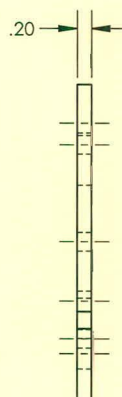
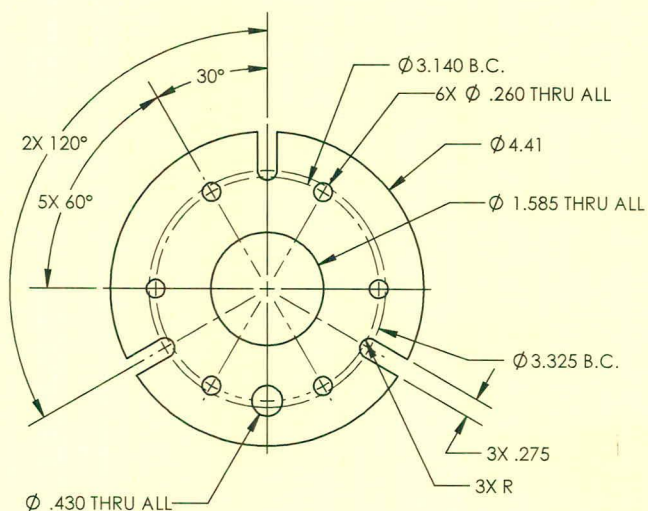
SCALE 1 : 2

(-5)
DISK

DART AEROSPACE	
TITLE EXTRACTOR FOR OUTER NEEDLE BEARING	
DWG NO. RBE105-14101W2-5	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH CLEAR ANODIZE	.XXX ± .005 FRACTIONS ± 1/8
SPEC MIL-A-8625, TYPE II, CLASS I	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES ± 125
DRAWN BY: CLOUGH	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.016 x 46° OR .016R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL
SCALE 1:4	EC145
DATE 12/30/2015	SHEET 4 OF 11

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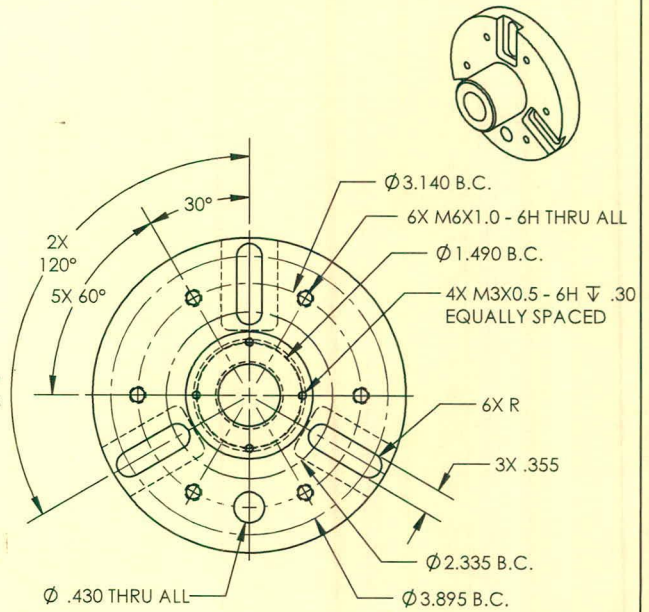
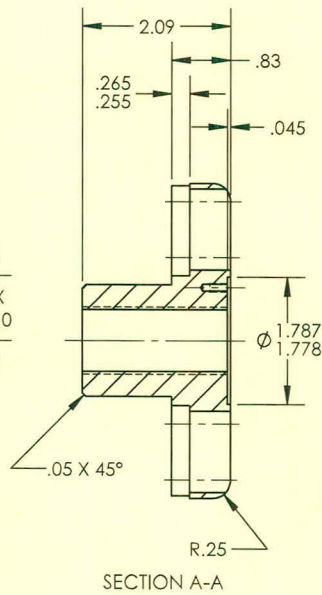
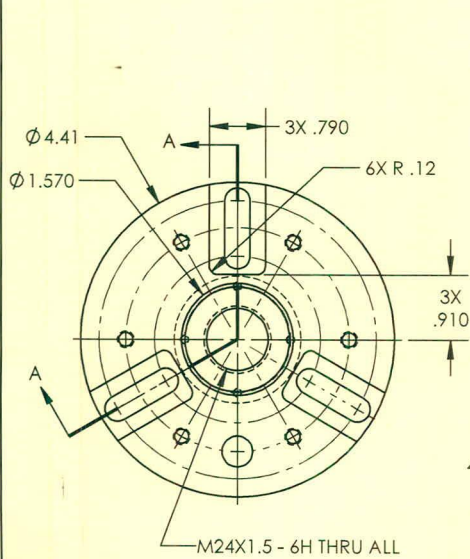


(-7)
PIN PLATE COVER

DART AEROSPACE	
TITLE EXTRACTOR FOR OUTER NEEDLE BEARING	
DWG NO. RBE105-14101W2-7	REV 1
MAT'L 4140/4142 Q & T	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXY ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
	EC145
SCALE 1:2	DATE 1/21/2016
	SHEET 5 OF 11

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REV	ECR	DESCRIPTION	DATE

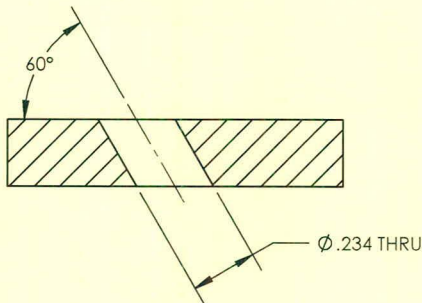


(-9)
PIN PLATE BASE

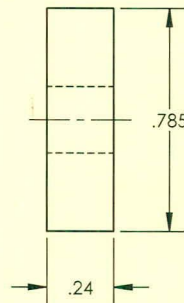
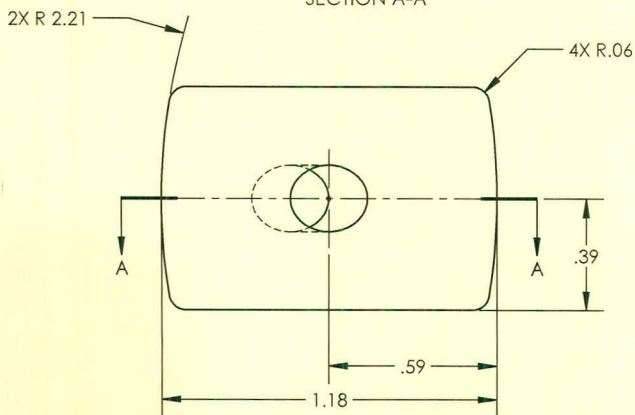
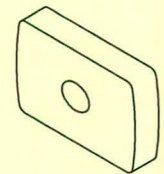
DART AEROSPACE	
TITLE EXTRACTOR FOR OUTER NEEDLE BEARING	
DWG NO. RBE105-14101W2-9	REV 1
MAT'L 4140/4142 Q & T HEAT TREAT FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2 DRAWN BY: DUERFELDT CHECKED: CLOUGH OPES APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS $\pm 1/8$ DECIMALS $\pm .01$ ANGLES $\pm 5^\circ$ SURFACES = 125 1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE 1:2	DATE 1/21/2016
SHEET 6 OF 11	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE



SECTION A-A



(-11)

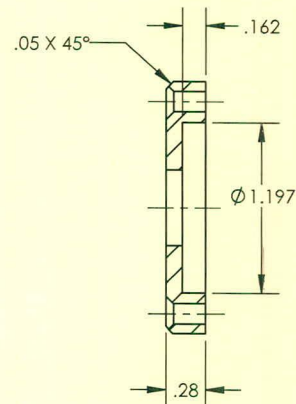
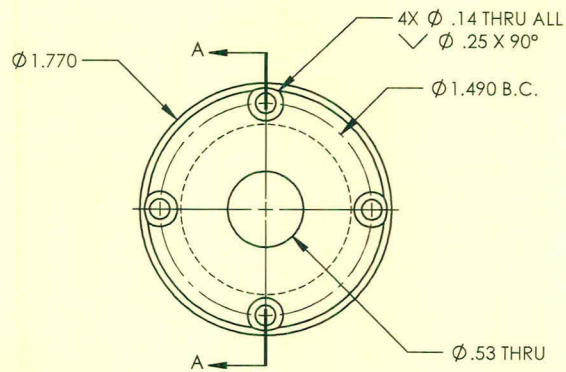
PLATE



TITLE		EXTRACTOR FOR OUTER NEEDLE BEARING	
DWG NO.	RBE105-14101W2-11	REV	1
MAT'L	4140/4142	UNLESS OTHERWISE SPECIFIED	
HEAT	HRC 40-45	DIMENSIONS ARE IN INCHES	
TREAT		.XXX ± .005	FRACTIONS ± 1/8
FINISH	ZINC PLATE	.XX ± .01	ANGLES ± 5°
SPEC	ASTM B633 TYPE I SC 2	.X ± .1	SURFACES = 125
DRAWN BY:	CLOUGH	1. BREAK ALL SHARP EDGES	
CHECKED:	CLOUGH	2. DIMENSIONAL LIMITS APPLY	
OPPS APPR:	ANDERSON	AFTER PLATING	
QA APPR:	LINDSAY	3. INTERPRET DIM AND TOL PER	
APPROVED:	GILBERT	ASME Y14.5M-2009	
		USED ON MODEL	
		EC145	
SCALE	2:1	DATE	12/31/2015
		SHEET 7 OF 11	

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SECTION A-A

(-13)

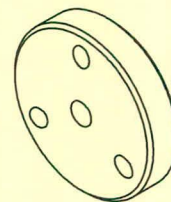
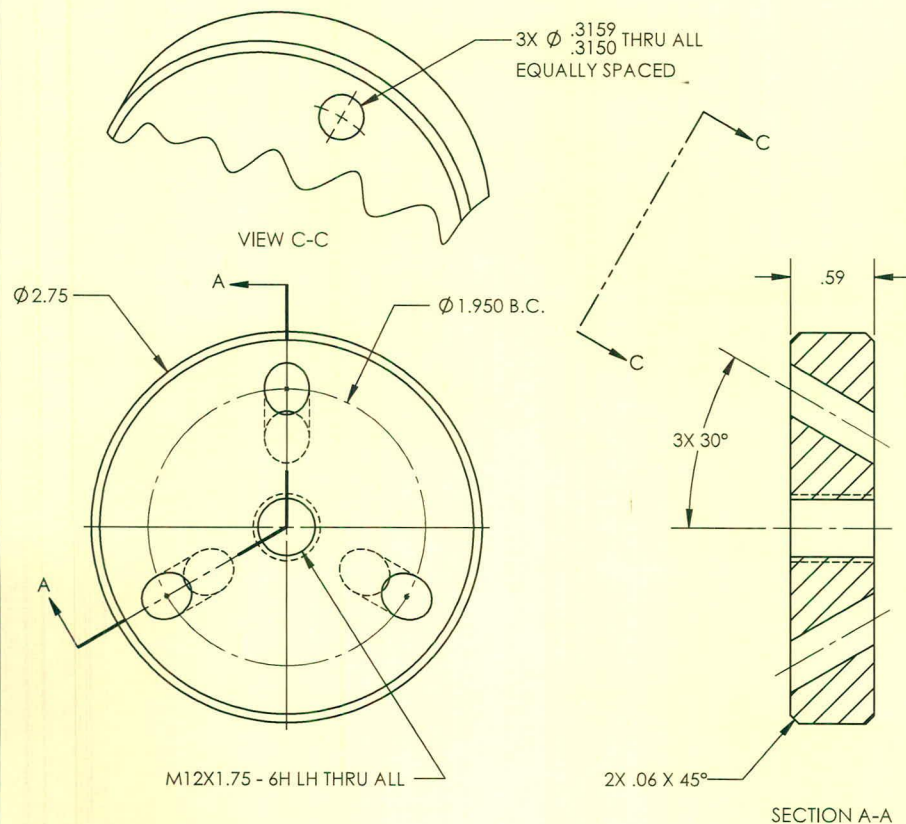
CAP



TITLE		EXTRACTOR FOR OUTER NEEDLE BEARING	
DWG NO.		RBE105-14101W2-13	
REV		1	
MAT'L	6061	UNLESS OTHERWISE SPECIFIED	
HEAT		DIMENSIONS ARE IN INCHES	
TREAT		.XXX ± .005 FRACTIONS ± 1/8	
FINISH	CLEAR ANODIZE	.XX ± .01 ANGLES ± .5°	
SPEC	MIL-A-8625, TYPE II, CLASS I	.X ± .1 SURFACES = 125	
DRAWN BY:	CLOUGH	1. BREAK ALL SHARP EDGES	
CHECKED:	CLOUGH	.016 X 45° OR .015R	
OPPS APPR:	ANDERSON	2. DIMENSIONAL LIMITS APPLY	
QA APPR:	LINDSAY	AFTER PLATING	
APPROVED:	GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
		USED ON MODEL	
		EC145	
SCALE	1:1	DATE	12/31/2015
		SHEET 8 OF 11	

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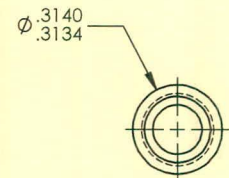
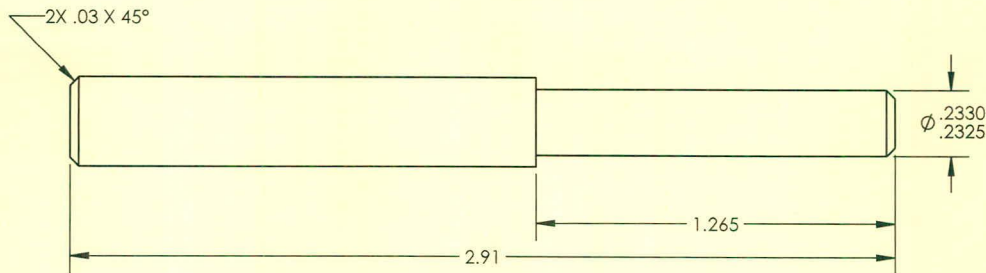
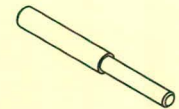
REVISIONS			
REV	ECR	DESCRIPTION	DATE



DART AEROSPACE	
TITLE EXTRACTOR FOR OUTER NEEDLE BEARING	
DWG NO. RBE105-14101W2-15	REV 1
MATL 4140/4142 HEAT RC 40-45 FINISH ZINC PLATE SPEC ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125
DRAWN BY: DUERFELDT CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 USED ON MODEL EC145
SCALE 1:1	DATE 1/21/2016 SHEET 9 OF 11

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				APPROVED



(-17)

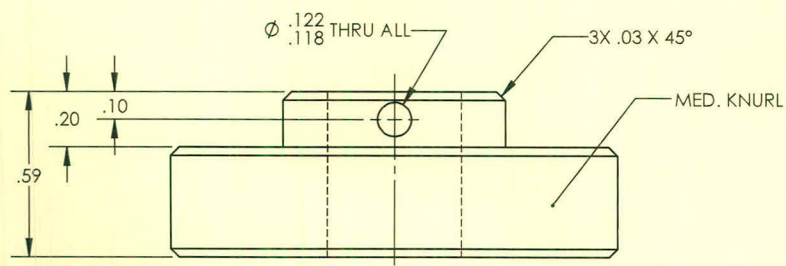
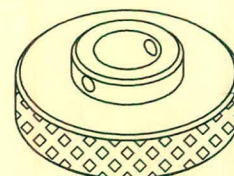
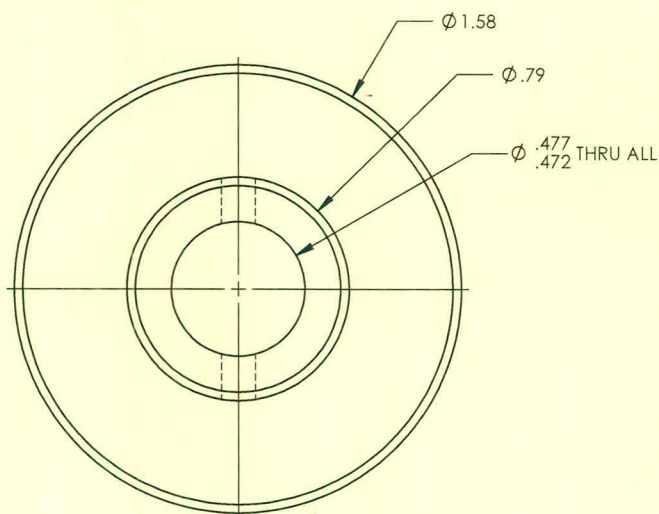
PIN



TITLE		EXTRACTOR FOR OUTER NEEDLE BEARING	
DWG NO.		RBE105-14101W2-17	
REV		1	
MAT'L	O-1	UNLESS OTHERWISE SPECIFIED	
HEAT	HRC 50-55	DIMENSIONS ARE IN INCHES	
TREAT	ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8	
FINISH	ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°	
SPEC		.X ± .1 SURFACES = 125	
DRAWN BY:	CLOUGH	1. BREAK ALL SHARP EDGES	
CHECKED:	CLOUGH	.015 x 45° OR .015R	
OPPS APPR:	ANDERSON	2. DIMENSIONAL LIMITS APPLY	
QA APPR:	LINDSAY	AFTER PLATING	
APPROVED:	GILBERT	3. INTERPRET DIM AND TOL PER ASME Y14.6M-2009	
SCALE	2:1	DATE	12/30/2015
		SHEET 10 OF 11	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE



(-19)

KNURLED KNOB

DART AEROSPACE	
TITLE EXTRACTOR FOR OUTER NEEDLE BEARING	
DWG NO. RBE105-14101W2-19	REV 1
MAT'L 6061	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH CLEAR ANODIZE	.XXX ± .005 FRACTIONS ± 1/8
SPEC MIL-A-8625, TYPE II, CLASS I	.XX ± .01 ANGLES ± 5°
DRAWN BY: DUERFELDT	.X ± .1 SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
QA APPR: LINDSAY	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
APPROVED: GILBERT	USED ON MODEL
SCALE 2:1	DATE 1/21/2016
SHEET 11 OF 11	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041411**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041411
PO Date: 10/22/18
Due Date: 12/14/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Via: Ground
Pymt Terms: Net 60

Freight Terms:
Special Comments:

Revised

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	185055	RBE105-14101W2P			Outer Needle Bearings Extractor	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$4,100.00/Ea	\$4,100.00
Line Item Note REV 1													
2	185058	RBE105-14101W18P			Pressing-In Tool	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$1,950.00/Ea	\$1,950.00
Line Item Note REV 1													
3	185059	RBE105-45045W1P			Trammel	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$4,900.00/Ea	\$4,900.00
Line Item Note REV 1													
4	185061	RBE105W27P			Main Gear Box Hoisting Device	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$0.01/Ea	\$0.01
Line Item Note REV 1													
5	185063	RBE105-31501W6P			Puller	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$820.00/Ea	\$820.00
Line Item Note REV 1													
6	185064	RBE105-31702W24P			Tail Rotor Fork Shaft Check	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$0.01/Ea	\$0.01
Line Item Note REV 1													
7	185065	RBE105-13101W3P			Disassembly / Assembly - Rotating Control Rod	Firmed	-	12/14/18	1 Ea	0 Ea	1 Ea	\$5,050.00/Ea	\$5,050.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041411**

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185106	RBE105-14101W12-1P			Mounting Shaft Assembly	Firmed	-	12/14/18 DEC 12 2018	1 Ea	0 Ea	1 Ea	\$520.00/Ea	\$520.00
Line Item Note Sub assy on part # RBE105-14101W12 REV 1													
9	185107	RBE105-14101W12-9P			Mounting Base	Firmed	-	12/14/18 DEC 12 2018	1 Ea	0 Ea	1 Ea	\$520.00/Ea	\$520.00
Line Item Note Sub assy on part # RBE105-14101W12 REV 1													
Grand Total:												\$17,860.02	

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses
A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

Plex 12/11/18 9:11 AM dart.Lussier.Patrick

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 Canada

Shipment No: 24364
Shipment Date: 10-Dec-2018
Ship Via: our truck
Order Number: 3112
Order Date: 10/24/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO041411 ✓
Terms: Net 60 Days

Quantity									
Item	Open	Shipped	B/O	Canceled	Unit	Description	Revision	Job Number	DA
1	1	1 ✓	0	0	EA	DART-RBE105-14101W2P Extractor for Outer Needle Bearing	1	3112-01	38 9-89
2	1	1 ✓	0	0	EA	DART-RBE105-14101W18P Pressing - In Tool	1	3112-02	
3	1	1 ✓	0	0	EA	DART-RBE105-45045W1P Trammel	1	3112-03	
5	1	1 ✓	0	0	EA	DART-RBE105-31501W6P Puller	1	3112-05	
7	1	1 ✓	0	0	EA	DART-RBE105-13101W3P Pitch Link Tool	1	3112-07	
8	1	1 ✓	0	0	EA	DART-RBE105-14101W12-1P MOUNTING SHAFT ASSEMBLY	1	3112-08	
9	1	1 ✓	0	0	EA	DART-RBE105-14101W12-9P MOUNTING BASE	1	3112-09	

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

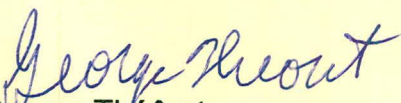
SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev#	P.O. Number	
1 ✓	RBE105-14101W2P ✓	Outer Needle Bearings Extractor	1	PO041411 ✓	DAE 38 9-89
1 ✓	RBE105-14101W18P ✓	Pressing-In Tool	1	PO041411 ✓	
1 ✓	RBE105-45045W1P ✓	Trammel	1	PO041411 ✓	
1 ✓	RBE105-31501W6P ✓	Puller	1	PO041411 ✓	
1 ✓	RBE105-13101W3P ✓	Pitch Link Tool	-	PO041411 ✓	
1 ✓	RBE105-14101W12-1P ✓	Mounting Shaft	1	PO041411 ✓	
1 ✓	RBE105-14101W12-9P ✓	Mounting Base	1	PO041411 ✓	
		No deviations for these part			
		Material supplied by METEC			

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.


George Théoret

Vankleek Hill, December 10, 2018

